

Work Order ID 81611

81611

Page 1

March-16-12 8:37:20 AM

Item ID: D058-677-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step RH

Stop ***NS2***

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/16 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2943

RevC

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD058-677-012

CHG 002

110

0.00

110

Large Fab

Memo

0.00

Large Fab

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and mounting plates as per Dwg D2943

A/R AL ROD

Batch: 120854

122130

4-Grind end cap welds flush as per dwg D2943

2 0 Ac
12-07-19
12-08-08

Ac
12-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81611

Page 2

N900040100

Setup Start ***NS1***

Stop ***NS2***

2

~

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
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Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

2

0

12.08.18

160

0.00

160

Large Fab

Memo

0.00

Large Fab

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482
A/R AL ROD Batch: 120854

2-Grind end cap welds flush as per dwg D2943

2

0

12.08.18
12.08.19

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
9-53 17/08/10

2

0

12.08.10

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	1-Pressure wash as per QSI 005 2-Touch up Chemical Conversion Coat as per QSI 005 4.1								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating									

Start Time: 11:15
Temp: 3200F
Finish Time: 11:45

m 121841

2X
RH
m 121841

W/O:		WORK ORDER CHANGES					
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Work Order ID 81611***81611***

Page 5

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step RH

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Wing Walk as per dwg QSI005 4.4 Batch M1172500

0.00

210

HandFinish

Memo

Hand Finishing

2RH 11/08/21

220

QC3- Inspect Part Finish

0.00

220

QC

Memo

0.00

Quality Control

2RH 12/08/21

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

DAS
16
8-83
17/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March-16-12 8:37:20 AM

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Page 6

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Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Pick Kit

0.00

240

Packaging

Memo

0.00

Packaging

241

QC4- 100% Inspect kits for completeness

0.00

241

QC

Memo

0.00

Quality Control

250

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D058-677-012

Location: 70

PPP Rev: _____



17/08/23

12/8/23

WORK ORDER CHANGES

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Picklist Print

March-16-12 8:37:24 AM

Page 2

Work Order ID: 81611

81611

Parent Item: D058-677-012

D058-677-012

Parent Item Name: Heli-Access-Step RH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3458-3 Manufactured No

110

Each

21.0000

2

4

D3458-3

Step Mounting Plate

**

12.08.24

Location

Loc Qty

Loc Code

WA002

B22116

21

75610

21

D2731-3 Manufactured No

240

Each

80.0000

**

D2731-3

D2731-3

Mounting Lug

Location

Loc Qty

Loc Code

ST469

80

73417

80

D3394-041 Manufactured No

240

Each

40.0000

**

D3394-041

D3394-041

Lug Assembly

Location

Loc Qty

Loc Code

ST479

40

74505

40

D2731-7 Manufactured No

240

Each

18.0000

**

D2731-7

D2731-7

Mounting Lug

Location

Loc Qty

Loc Code

ST

-50

ST468A

18

69177

12

71083

2

71860

4

ST469

50

March-16-12 8:37:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-16-12 8:37:24 AM

Page 3

Work Order ID: 81611

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Parent Item: D058-677-012

D058-677-012

Parent Item Name: Heli-Access-Step RH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

240

Each

152.0000

8

16

AN4-14A

Bolt

**

M122141

af

Location

Loc Qty

Loc Code

ST357

152

118451

5

119798

84

120187

13

120769

50

D3394-043

Manufactured

No

240

Each

48.0000

2

4

D3394-043

Lug Assembly

**

B80217

sl

Location

Loc Qty

Loc Code

ST479

48

69180

12

71082

1

72520

1

78921

34

AN960ID416

NAS1149D0463J Purchased

No

240

Each

14.0000

12

24

AN960.ID416

Washer

**

M122441

12/8/22 af

Location

Loc Qty

Loc Code

ST351

14

116289

14

March-16-12 8:37:24 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-16-12 8:37:24 AM

Page 4

Work Order ID: 81611

81611

Parent Item: D058-677-012

D058-677-012

Parent Item Name: Heli-Access-Step RH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

240

Each

5,527.000

12

24

MS21042L4

Nut

**

M1224525

Location

Loc Qty

Loc Code

ST300

5527

117441

51

117601

157

118451

133

119017

200

119075

2986

121011

2000

AN4-15A

Purchased

No

240

Each

375.0000

4

8

AN4-15A

Bolt

**

M12214150

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

275

118706

15

120187

60

120422

200

D2732-030

Manufactured

No

240

Each

9.0000

8

16

D2732-030

Rubber Cushion

**

B 83560 12/8/254
4/4

Location

Loc Qty

Loc Code

ST402

9

76850

3

78144

6

March-16-12 8:37:24 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

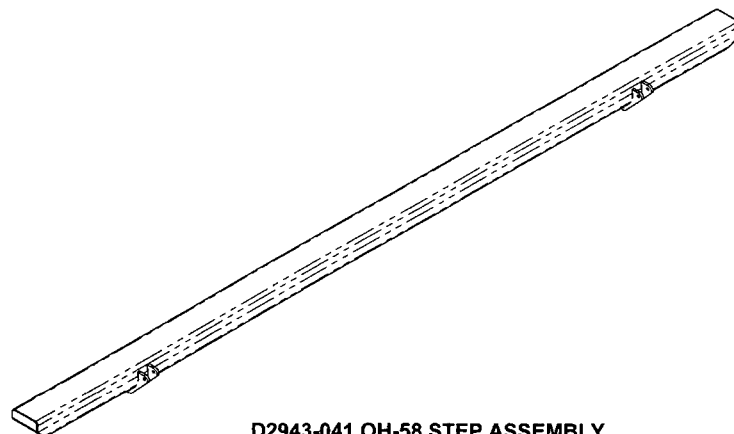
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

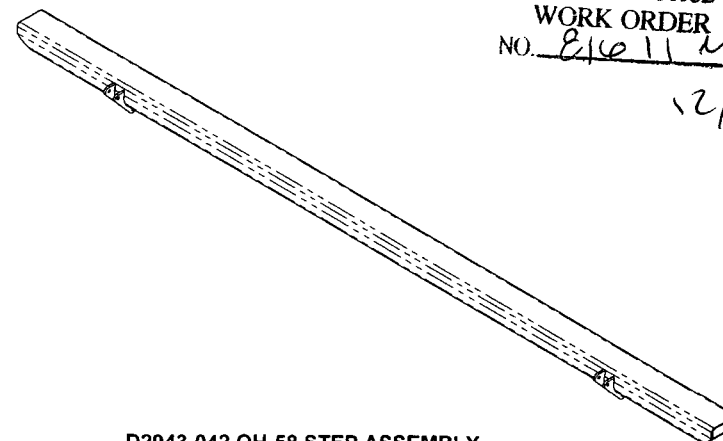
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ITEM No.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D2943-041	OH-58 STEP ASSEMBLY, LH
2		X	D2943-042	OH-58 STEP ASSEMBLY, RH
7	1	1	D2943-1	STEP
11	2	2	D2734	END PLATE
12	2	2	D3458-1	STEP MOUNTING PLATE
13	2	2	D3458-3	STEP MOUNTING PLATE



D2943-041 OH-58 STEP ASSEMBLY



D2943-042 OH-58 STEP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81611 MLO

12/03/16

RELEASED
09/06/25 MLO

D2943-041/-042 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.31 lbs
- 8) WELD PER QSI 004

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS ATTACHMENT CHANGED FROM SINGLE LUG TO DOUBLE LUG. D2725 REPLACED BY ITEMS 12 & 13. REASON SEE PAR 152. ADDED ITEM 7, D2622-082 MOVED FROM P/L TO NOTES ON SHEET 3.	AJS	08.11.17
B	UPDATED FINISHING NOTE	PH	05.11.14
A	NEW ISSUE	RF	99.11.19
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D2943	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		OH-58 STEP ASSEMBLY	NTS
DATE	08.11.17	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

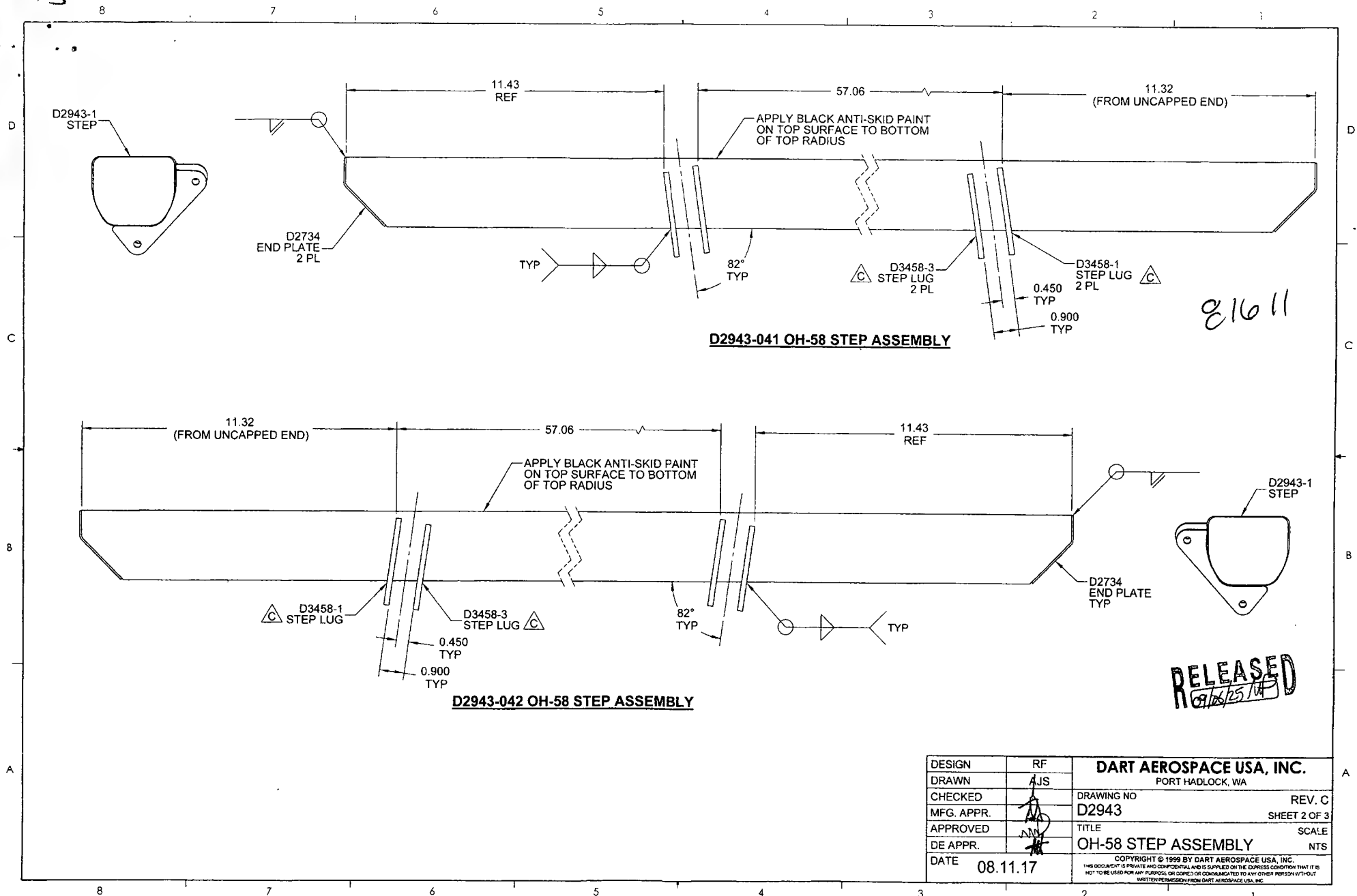
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D2943	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		OH-58 STEP ASSEMBLY	NTS
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Dart Aerospace Ltd

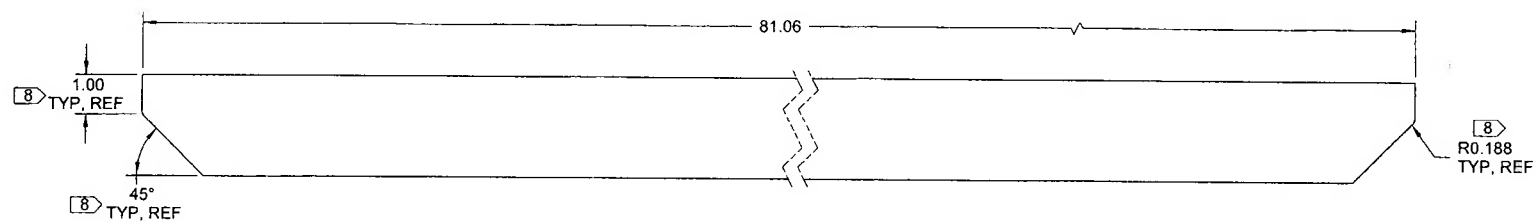
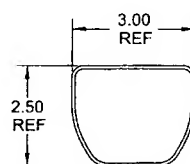
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NOTE: Date & initial all entries

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D2943-1 STEP $\triangle C$

RELEASED
01/06/25 MP

D2943-1 NOTES:

- 1) MATERIAL: MAKE FROM D2622-082 EXTRUSION $\triangle C$
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.93 lbs
- 8) SHAPE TO FIT D2734 END CAP

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AUS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2943	SHEET 3 OF 3
APPROVED	NN	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OH-58 STEP ASSEMBLY	NTS
DATE	08.11.17	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

WORK ORDER CHANGES

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NCR:

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NOTE: Date & initial all entries

4.0 PARTS LIST:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D058-677-011	HELI-ACCESS-STEP™, LH
	X			D058-677-012	HELI-ACCESS-STEP™, RH
		X		D058-677-013	HELI-ACCESS-STEP™, LH
			X	D058-677-014	HELI-ACCESS-STEP™, RH
1		1		D2943-041	STEP ASSEMBLY LH
	1		1	D2943-042	STEP ASSEMBLY RH
		2	2	D3394-045	MOUNTING LUG (REPLACES D2230-1)
		2	2	D2230-3	MOUNTING LUG
2	2			D3394-041	MOUNTING LUG (REPLACES D2731-1)
2	2			D2731-3	MOUNTING LUG
2	2	2	2	D3394-043	MOUNTING LUG (REPLACES D2731-5)
2	2	2	2	D2731-7	MOUNTING LUG
8	8	8	8	D2732-030	RUBBER CUSHION
8	8	4	4	AN4-14A	BOLT
4	4	4	4	AN4-15A	BOLT
		4	4	AN4-16A	BOLT
12	12	12	12	AN960JD416	WASHER
12	12	12	12	MS21042L4	NUT (OR MS21042-4)

5.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D058-677-011/-013 HELI-ACCESS-STEP™, LH	8.15 lb 3.70 Kg	- 36.5 in - 0.93 m	- 297.5 in-lb - 3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG
D058-677-012/-014 HELI-ACCESS-STEP™, RH	8.15 lb 3.70 Kg	+36.5 in +0.93 m	+297.5 in-lb +3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG

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